

5/25

DART AEROSPACE LTD	Work Order:	23578
Description: Step Leg	Part Number:	D3077-1
RF 03.02.28	RF 03.02.28	D3170 -1
Dwg: D3077 Rev. A ^t A2	D3170 Rev. A	Qty: 30
RF 03.02.17		Page 1 of 1
		Stack of 10

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller		05.06.16	30
2	MV	Cut blanks: 12.100" x 5.070" (+0.030/-0.000) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Identify as D3077-1		SA 05.06.18	30
3	MV	Cut blanks: 11.990" x 0.750" (-0.00/+0.010) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Identify as D3170-1		SA 05.06.18	30
4	MV	Machine per Folio FA284 and Dwg D3077		SA 05.06.19	40
5	QC2	Inspect parts as they come off the CNC machine		SA 05.06.19	40
6	MV	Deburr to take measurement		SA 05.06.19	40
7	QC8	Second inspection	EZ	05.06.19	40
8	MV	Machine per Folio FA282 and Dwg D3170		SA 05.06.19	37
9	QC2	Inspect parts as they come off the CNC machine		SA 05.06.19	37
10	MV	Deburr to take measurement		SA 05.06.19	37
11	QC8 & 5	Second inspection	EZ	05.06.20	37
12	GA	Deburr D3077-1 and D3170-1 stack 40 FF 37 FF	FF	05.06.22	37/40
13	FP	Acid etch and Alodine per QSI 005 4.1 D3077-1 and D3170-1	FF	05.06.22	37/50
14	QC5	Inspect work to Step 13	Z	05.06.23	37/40
15	GA	Identify and Stock D3077-1 and D3170-1	Z	05.06.23	37/40
16	AC	Cost / part 1.96 3.66	SAC	05.06.24	37/40
17	DC	Close W/O 5.93 3.66 Inspect Level 21	EZ	05/07/05	37

Rev	Date	Change	Revised By	Approved
A	02.10.11	New issue	KJ	
B	02.11.18	Incorporated D3170-1 IPP	KJ RF	

RELEASED
02-11-20 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/06/20	8	3 x 3170-1 spacer scrap to deep of scratches on the material	 prospero	scraps: destroy	05/06/20	2 05-06-20	 prospero	 05-06-20

Part No: D3077-1/D3170-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/07/20

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD	Work Order:	23578
Description: Step Leg	Part Number:	D3077-1
Inspection Dwg: D3077	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SA</u>	Audited by:	<u>E</u>	Prototype Approval:	N/A
Date:	05.06.19	Date:	05.06.19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	<i>[Signature]</i>

~~RELEASED~~

DART AEROSPACE LTD	Work Order:	23578
Description: Spacer	Part Number:	D3170-1
Inspection Dwg: D3170	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	S A
Date:	05.06.19

Audited by:	<u>PC</u>
Date:	05.06.28

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D3077-1	KJ/JLM	JL

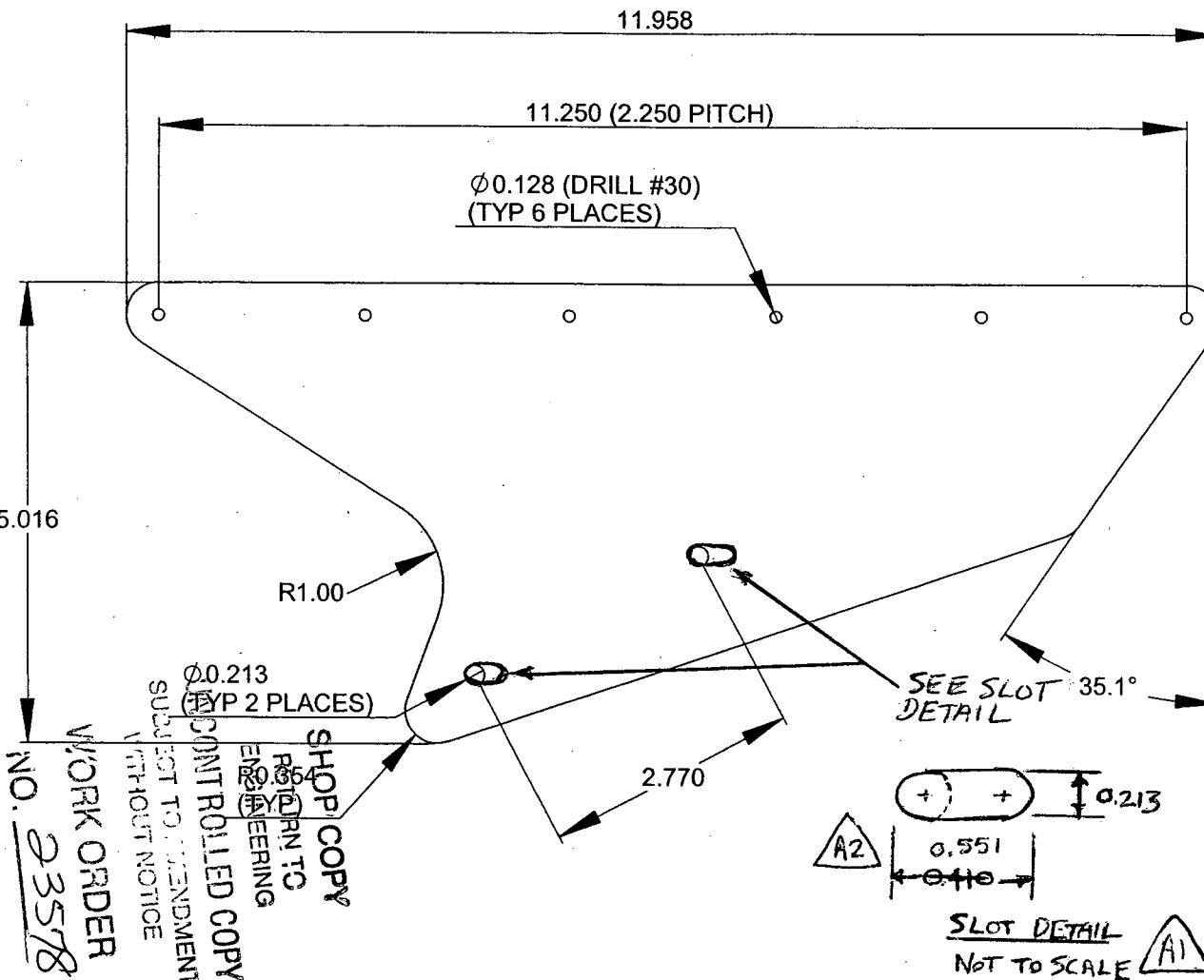
H:\FORMS\Quality Assurance\approved QA\FAI revD

RELEASED

DARTDRAFT COPY
DRAFT**RELEASED**

02.04.2004

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3077
		REV. A
DATE	02.09.11	SHEET 1 OF 1
A	02.09.11	SCALE
A1	03.02.13 DRAFT	1:2
A2	03.02.27 UPD	

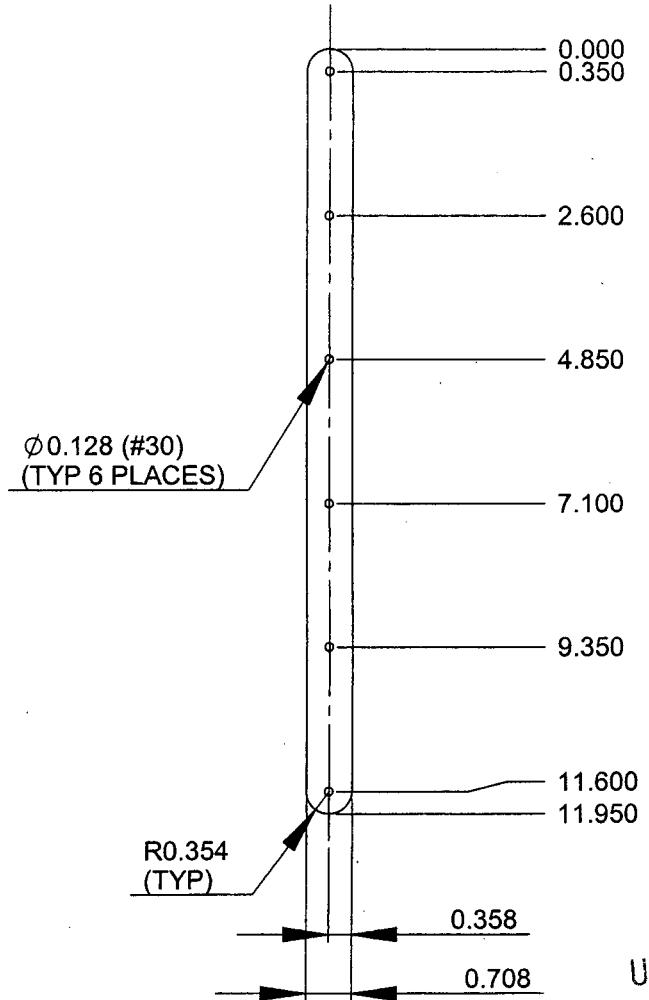
**D3077-1 STEP LEG**

- 1) MACHINE PER DWG FILE "D3077-1.SLDPRPT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



COPY ISSUE

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3170	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *[initials]*SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. *23518***D3170-1 SPACER**

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
HawkesburyJun 16, 2005
08:04 am

Work Order No : 0023578
 Project Name : D3077-1
 Project For : WK525
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3077-1
 Description : Step Leg
 Manufactured : Yes
 Amount Req'd : 30
 Amount Done : 0
 Start Date : 06-15-05
 Est Finish Date : 06-24-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00